

162.56

Dart Aerospace Ltd.

Date: Thursday, 4/12/2007 9:08:04 AM
 User: Kim Johnston

Process Sheet

| | |
|--|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : ESCUTCHEON |
| Job Number : 31757 | |
| Estimate Number : 11130 | |
| P.O. Number : | Part Number : D31101 |
| This Issue : 4/12/2007 S.O. No. : | Drawing Number : D3110 REV <i>XC</i> OK <i>07.04.16</i> |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : 11 Type : MACHINED PARTS | Drawing Revision : <i>XC</i> |
| Previous Run : | Material : |
| Written By : | Due Date : 4/18/2007 Qty: <i>8</i> Um: Each |
| Checked & Approved By : <i>07.04.16</i> | |
| Comment : Est. B <i>07.04.30</i> Added Rev.A1 NG | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|--------------------|--------------------------|
| 1.0 | M6061T6B0250X01250 | 6061-T6 Bar .25" X 1.25" |
|-----|--------------------|--------------------------|



Comment: Qty.: 0.3500 f(s)/Unit Total: 0.6999 f(s)
 6061-T6 Bar .25" X 1.25"
 Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8)

Batch: *M10956*

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW
 Cut blanks: 6.400" x 1.25" x .25" thick
 Note: 1 blank makes 2 parts

SA 07.11.22

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio FA215

JSP 07/12/13

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JSP 07/12/13

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

*SG 07.12.14**(8)*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 28/02/10
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:08:04 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ESCUTCHEON

Job Number: 31757

Part Number: D31101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble or Deburr Polish to a high lustre!

AS 08/02/07 *8B 08/02/08* *(8)*

(8)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Bag and Tag
Identify with p/n and b/n using fine point permanent ink marker.
Identify and Stock
Location: *3T65*

AS 08/02/08 *(x8)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/08/02/12 *(8)*

Job Completion



min 2008/2/11 *(8)*

W

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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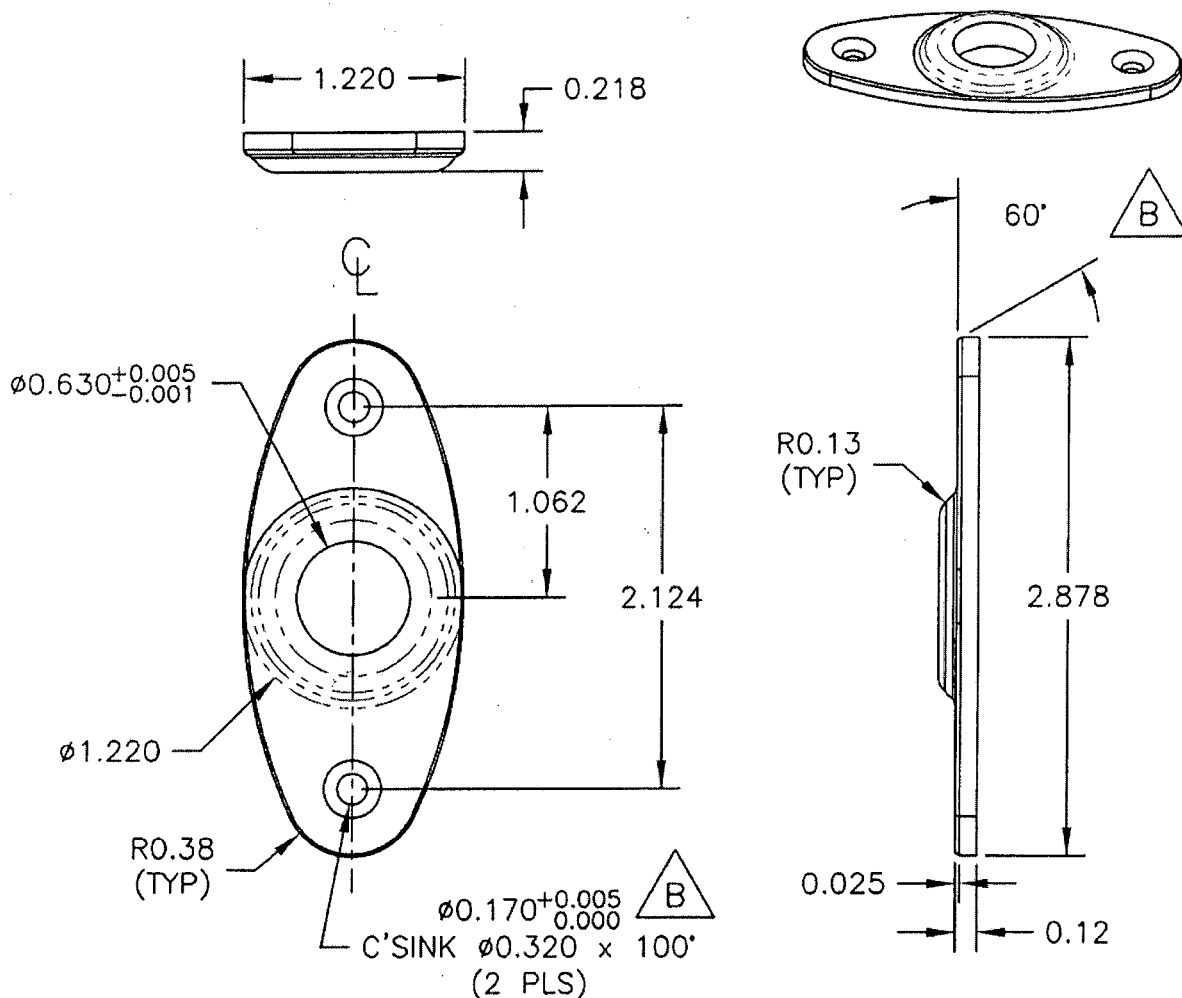
NOTE: Date & initial all entries



| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3110 | REV. C SHEET 1 OF 3 |
| DATE 05.12.14 | TITLE HANDLE | | SCALE 1:1 |
| A | 02.04.11 | NEW ISSUE | |
| B | 04.10.18 | ADD PART MARKING, TOLERANCES | |
| C | 05.12.14 | REVISE D3110-5 | |

RELEASED

05.12.15 *[Signature]*



D3110-1 ESCUTCHEON

NOTES:

- 1) MATERIAL: 6061-T6 BAR (QQ-A-200/8 OR QQ-A-225/8) 0.250 THICK
- 2) FINISH: POLISHED
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) REPLACES ADAMS RITE P/N AR75
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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WITHOUT NOTICE
WORK ORDER
NO. 31757

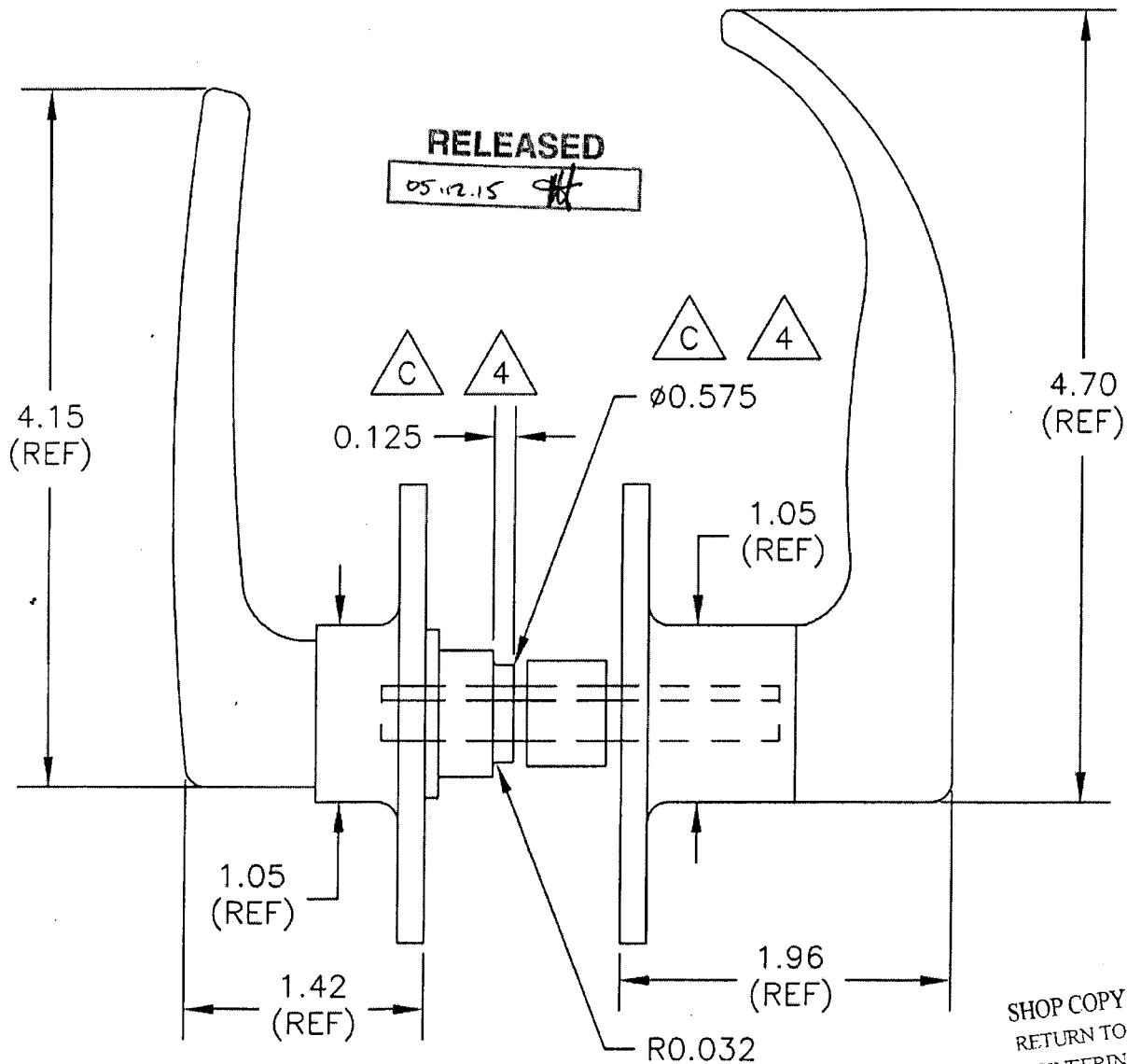
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| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3110 | REV. C SHEET 3 OF 3 |
| DATE 05.12.14 | | TITLE HANDLE | SCALE 1:1 |

SPECIFICATION CONTROL DRAWING



D3110-5 HANDLE

NOTES:

- 1) POSSIBLE SUPPLIER: ADAMS RITE P/N 4298
- 2) IDENTIFY WITH PART P/N USING FINE POINT PERMANENT INK MARKER
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) MODIFY STEM AS SHOWN
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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